



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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C45-3-11**Job Sheet 193438****Part No:** C45-3-11**Job Qty:** 20 pcs**Part Name:** Actuator**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 4/15/19**Job Tracking No:****Due Date:** 5/10/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** C45-3-11 rev.8 IPP REV:A 18.02.06 NEW ISSUE DD VERF:DP**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	NLX 2500SY - 1	20 pcs	5/10/19	5/10/19	0.00	4.00	NLX 2500SY - 1		
130	QC 2	20 pcs	5/10/19	5/10/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

**Container No:** S175232**Part:** C45-3-11**Job No:** 193438**Serial No/Batch:** S175232**Revision:** 8**Inspector:****Exp Date:****Instructions:**

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Date: 04/25/19

				QC 2 - 5	
				QC 2 - 71	DAS
132 HAAS 4 Axis - B4B	20 pcs	5/10/19	0.00 0.00	HAAS - 1 - B4B	52 19/05/02
134 QC 2	20 pcs	5/10/19	0.00 0.00	QC 2 - 1	9-89 19/05/02
140 QC 8	20 pcs	5/10/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	Δ = 19-05-04
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
150 Packaging 3-2 - Stock - B4B	20 pcs	5/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

4/22/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160 QC 21 - FG	20 pcs	5/10/19	0.00	0.00	QC 21 - FG - 21	DAG
					QC 21 - FG - 70	21
					QC 21 - SA - 53	2-53

MAY 06 2019

Part Op 120 - MORI NLX 2500SY LATHE)1-Machine as per folio FB820 FOLIO REV: AA DWG REV: 8
 Descriptions: 2-Deburr
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 132 - 1-Machine as per folio FB820 FOLIO REV: 8 DWG REV: 8 2-Deburr
 140 - QC8- Inspect parts - second check)
 150 - I(Identify as per dwg & Stock Location: _____)identify and Stock
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-R2.000	M174R2.000	3.6000 ft (.18 ea)	120-NLX 2500SY - 1	545231

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-NLX 2500SY - 1	M17-4-R2.000	4	12	0

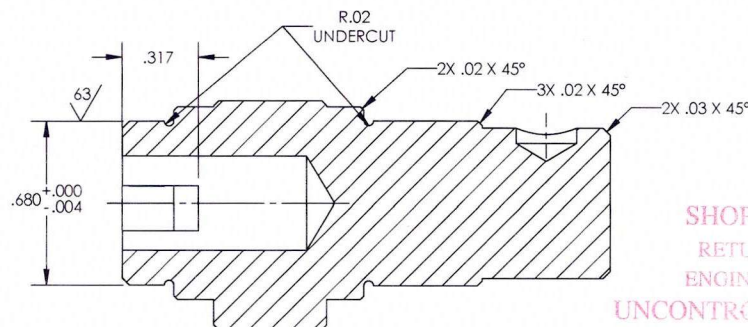
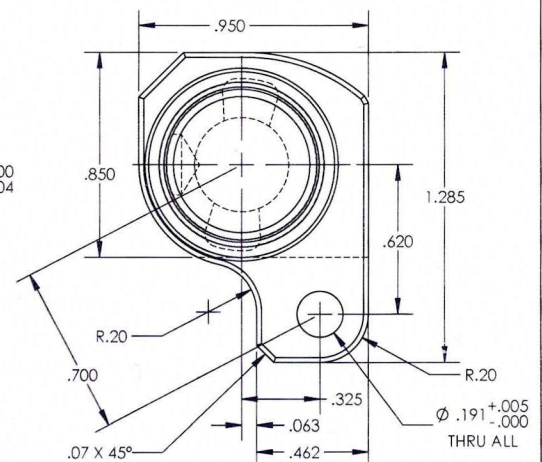
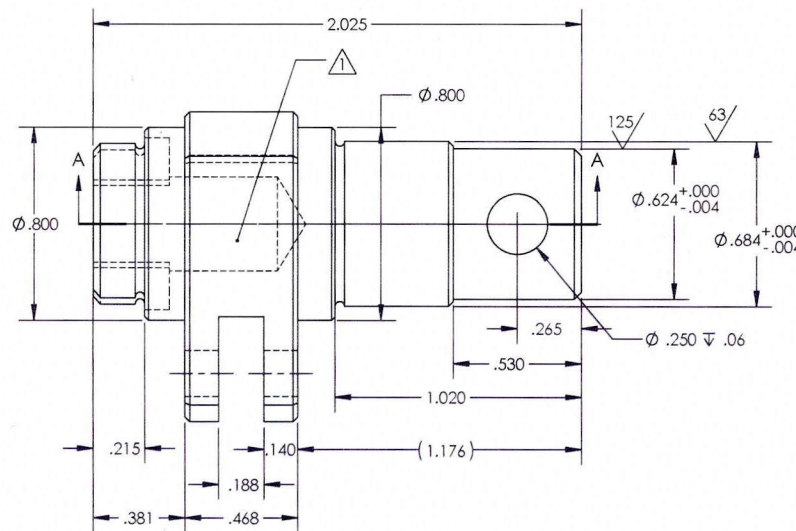
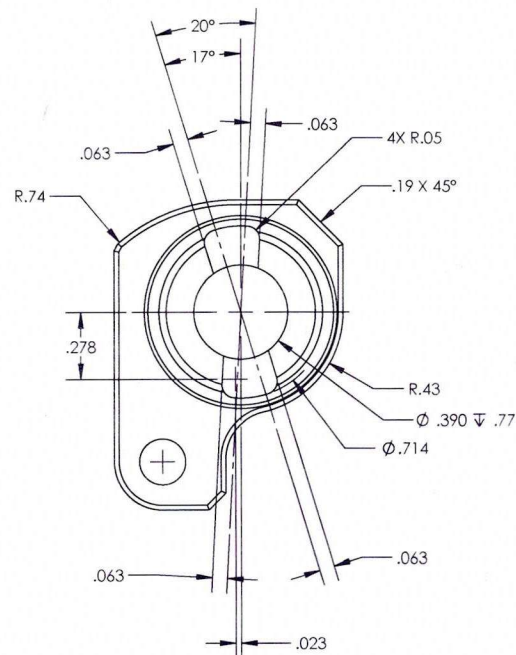
Part Specifications

Specifications could not be found.

Plex 4/22/19 1:21 PM Dart.lajeunesse.marie

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
6		AS DRAWN BY CANAM.	9/12/2012	RJC
7		CHANGED HOLE FROM Ø.188 TO Ø.191	10/30/2012	JAG
8	14-0126	CHTD TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE. CHTD TOLERANCE ON NON-CRITICAL DIMENSIONS. CHTD B/O INFO WAS 1 X 1-1/2 X 2-1/4 & Ø2 X 2-1/8.	8/13/2014	DPD
				RW



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193438 MLJ
1904-15

NOTE:
MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE ACTUATOR	
DWG NO. C45-3-11	REV 8
MAT'L 17-4 S.S.	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED: <i>P. Wood</i>
.XXX ± .005 FRACTIONS ± 1/8	REPT
.XX ± .01 ANGLES ± 5°	FINISH
OR .015R	SPEC
1. BREAK ALL SHARP EDGES .015 X 45°	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 1/28/1998
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-3-11	1	ACTUATOR	17-4 S.S.	Ø2 X 2-1/8

PORT AEROSPACE LTD		Work Order: 193438
Description: Actuator		Part Number:
Inspection Dwg: C45-3-11	Rev: 8	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
19x45°	±.01x.5°	18.8x45°			Vern LPI0	
Ø.390	±.005	.394				
.77	±.01	.780				
Ø.714	±.005	.713				
Ø.800	±.005	.800				
2.025	±.005	2.030				
.215	±.005	.215				
.381	±.005	.381				
.468	±.005	.465				
.188	±.005	.187				
.140	±.005	.137				
1.020	±.005	1.030				
.530	±.005	.535				
.265	±.005	.265				
.250	±.005	.250				
.06	±.01	.06				
Ø.624	+ .000 / - .004	.624				
Ø.684	+ .000 / - .004	.681				
Ø.800	±.005	.798				
Ø.680	+ .000 / - .004	.678				
.317	±.005	.317				
.02x45°	±.01x.5°	.02x45°				
.03x45°	±.01x.5°	.03x45°				
.950	±.005	.952				
.850	±.005	.850				
1.285	±.005	1.287				
.620	±.005	.6175			H-Gauge	
.700	±.005	.6965			Vern LPI0	
.063	±.005	.062			H gauge	

Measured by: [Signature]	Checked by: [Signature]	QC Inspector:
Date: 19-04-22	Date: 19-05-04	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by
A	14.07.31	New Issue	KJ

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	